

Work Order ID 55017

January 5, 2010 12:58:23 PM



Page 1

Item ID: D2665-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PD

Date: 10-1-05

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2665

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

DIT 10/02/08

6 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

DIT 10/02/08

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DIT 10/02/08

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

10.2.8

6

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

10-02-09

26

8

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1113170

Powdercoat

Memo

0.00

10/02/09

26

8

Powder Coating

START TIME: 8:00AM
FINISH TIME: 8:30AM

OVEN TEMPERATURE:
320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

January 5, 2010 12:58:23 PM

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Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 5/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

BR 10-02-9

⑥ φ

QC

Memo

0.00

Quality Control

170



Identify as per dwg & Stock Location: 436

0.00

Packaging

Memo

0.00

Packaging

Per 11/11/10

180



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/11

-ME

10-2-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:58:27 PM

Page 1

Work Order ID: 55017



Parent Item: D2665-1



Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D6101-003

Manufactured No

100

Each

11.0000

6.0000



Saddle Billet, 7075

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

11

46410

11

6 DTA 10/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55017
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.122	0.120	0.120	0.118		
B	0.100	0.140		0.110	0.108	0.106	0.106		
C	1.125	1.125		1.134	1.132	1.132	1.133		
D	0.615	0.685		0.650	0.650	0.650	0.650		
E	0.240	0.260		0.258	0.257	0.258	0.254		
F	1.313	1.343		1.327	1.327	1.327	1.327		
G	0.210	0.230		0.222	0.222	0.224	0.222		
H	0.100	0.180		0.140	0.140	0.140	0.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.566	1.5655	1.565	1.565		
K	0.235	0.240		0.2375	0.2375	0.237	0.237		
L	0.100	0.120		0.120	0.115	0.115	0.115		
M	0.990	1.010		1.004	1.004	1.003	1.003		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.005	6.005	6.004	6.004		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.317	0.317	0.317	0.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.795	0.794	0.794	0.794		
W	0.540	0.560		0.553	0.551	0.552	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.920	0.921	0.921	0.921		
AA	0.490	0.510		0.498	0.498	0.497	0.498		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP
Date:	10/02/08

Audited by:	RF
Date:	10.2.08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD	Work Order:	55017
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.119	0.118	0.119			
B	0.100	0.140		0.104	0.103				
C	1.125	1.145		1.1335	1.133				
D	0.615	0.685		0.650	0.650				
E	0.240	0.260		0.257	0.256				
F	1.313	1.343		1.325	1.325				
G	0.210	0.230		0.221	0.221	0.222			
H	0.100	0.180		0.140	0.140				
I	2.470	2.510		2.495	2.495				
J	1.565	1.585		1.5655	1.565				
K	0.235	0.240		0.238	0.238				
L	0.100	0.120		0.115	0.115				
M	0.990	1.010		1.003	1.003				
N	0.510	0.515		0.510	0.510				
O	5.990	6.010		6.003	6.003				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		0.315	0.315				
S	0.315	0.322		0.317	0.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		0.794	0.794				
W	0.540	0.560		0.552	0.552				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		0.259	0.259				
Z	0.912	0.932		0.921	0.921				
AA	0.490	0.510		0.499	0.499				
AB	0.178	0.198		0.188	0.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	DJP
Date:	10/02/08

Audited by:	up
Date:	10.2.8

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

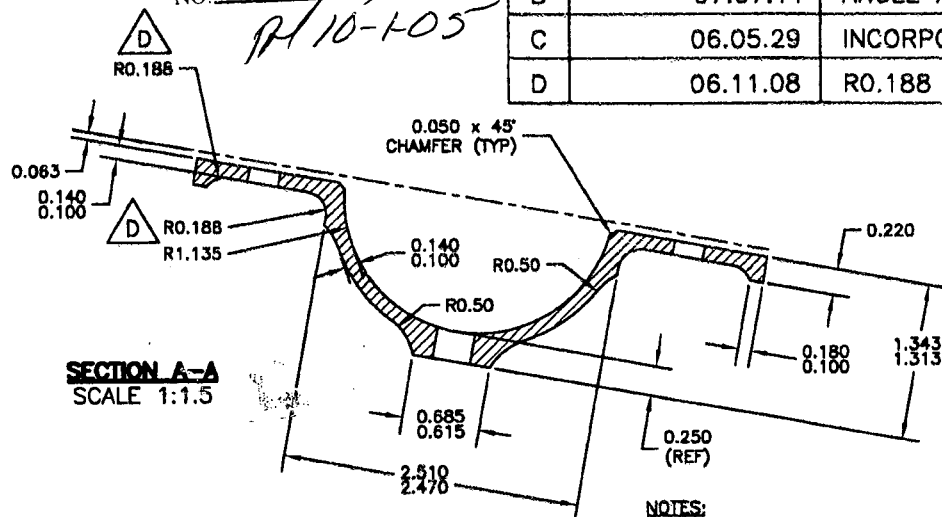


ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 55017

PH10-105

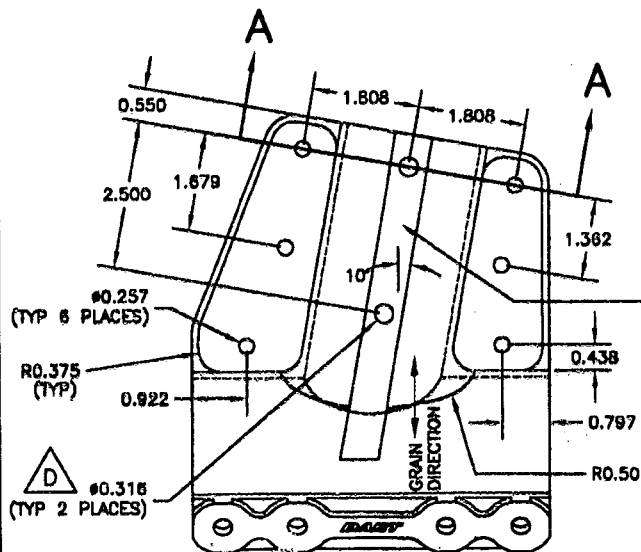
DESIGN	<u>PH</u>	DRAWN BY	<u>CB</u>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<u>PH</u>	APPROVED	<u>CB</u>	DRAWING NO. D2665
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	RO.188 WAS R0.30; Ø0.316 WAS Ø0.313		



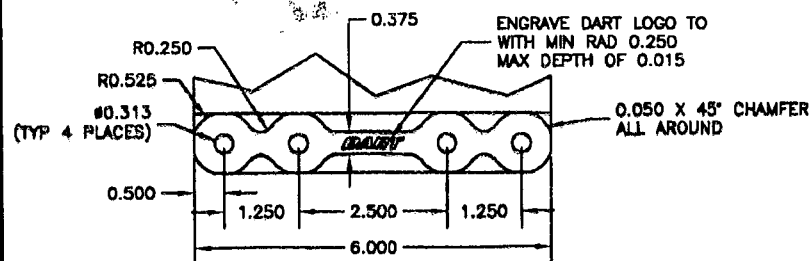
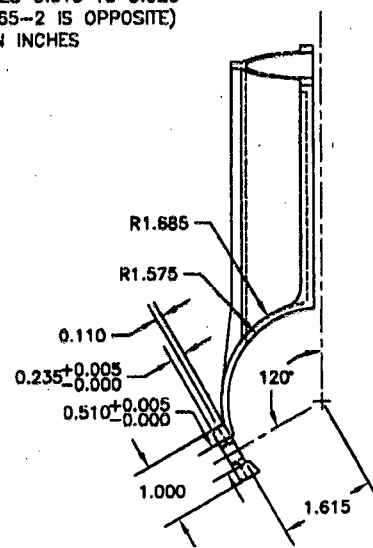
RELEASED
07.02.12

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



ENGRAVE DART LOGO TO
WITH MIN RAD 0.250
MAX DEPTH OF 0.015

D2665-1 SADDLE FWD OUTSIDE HIGH

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NOTE: Date & initial all entries